



Dart Aerospace Ltd.  
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Hawkesbury, ON  
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Tel (613) 632-5200

**D3278-1**  
**Job Sheet 172750**



Part No: D3278-1

Job Qty: 60 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/5/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG, REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off              |
|-------|------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-----------------------|
|       |                        |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                       |
| 90    | Start up Operation     | 60 Ea  | 3/2/18     | 3/2/18   | 0.00      | 0.00    | Start Up Machining-2  |           | <i>SA</i> 18-03-03    |
| 100   | Bandsaw                | 60 pcs | 3/2/18     | 3/2/18   | 0.00      | 1.73    | Bandsaw1              |           | <i>SA</i> 18-03-03    |
| 110   | CNC Vertical Machining | 60 pcs | 3/3/18     | 3/3/18   | 0.06      | 18.82   | HAAS 5 Axis           |           | <i>SA</i> 18-03-03    |
| 125   | Packaging              | 60 pcs | 3/3/18     | 3/3/18   | 0.00      | 0.00    | Packaging2            |           | <i>DAS</i>            |
| 130   | QC                     | 60 pcs | 3/3/18     | 3/3/18   | 0.00      | 0.00    | QC6                   |           | <i>38</i>             |
| 140   | HandFinish             | 60 pcs | 3/3/18     | 3/3/18   | 0.00      | 0.57    | HandFinish1           |           | <i>SA</i> 18-03-06    |
| 150   | Powdercoat             | 60 pcs | 3/5/18     | 3/5/18   | 0.00      | 0.45    | Powdercoat1           |           | <i>SA</i> 18-03-06    |
| 160   | QC                     | 60 pcs | 3/5/18     | 3/5/18   | 0.00      | 0.00    | QC3                   |           | <i>SA</i>             |
| 170   | Packaging              | 60 pcs | 3/5/18     | 3/5/18   | 0.00      | 0.00    | Packaging3-1          |           | <i>SA</i>             |
| 180   | QC21-SA                | 60 Ea  | 3/5/18     | 3/5/18   | 0.00      | 0.00    | QC21                  |           | <i>SA</i> MAR 07 2018 |

Part Op 100 - Cut blank: 2.00" x 1.00" x 2.550" long  
Descriptions: 110 - 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1  
150 - START TIME: 10:00 AM OVEN TEMPERATURE: 320°F FINISH TIME: 10:30 AM  
170 - LOCATION : GA

### Job BOM

| Part / Item          | Component Name          | Quantity              | Operation             | Container                              |
|----------------------|-------------------------|-----------------------|-----------------------|----------------------------------------|
| M6061T6B1.000X02.000 | 6061-T6 Bar 1.00 X 2.00 | 14.0220 ft (.2337 ea) | 90-Start up Operation | <i>SA</i> 5046626<br><i>SA</i> 5046736 |

### Job Allocations

| Operation             | Component Part       | Required | Inventory | Allocated |
|-----------------------|----------------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6B1.000X02.000 | 14       | 34        | 0         |

| Part Specifications |             |                                |                |      |                  |
|---------------------|-------------|--------------------------------|----------------|------|------------------|
| Spec No             | Description | Target/Tolerance               | Limits         | Type | Special Comments |
| 1                   | Support     | 0.098inches + 0.005<br>- 0.000 | 0.103<br>0.098 |      |                  |
| 2                   | Support     | 0.359inches ± 0.005            | 0.364<br>0.354 |      |                  |
| 3                   | Support     | 0.609inches ± 0.010            | 0.619<br>0.599 |      |                  |
| 4                   | Support     | 0.250inches ± 0.010            | 0.260<br>0.240 |      |                  |
| 5                   | Support     | 1.480inches ± 0.005            | 1.485<br>1.475 |      |                  |
| 6                   | Support     | 0.125inches ± 0.010            | 0.135<br>0.115 |      |                  |
| 7                   | Support     | 0.119inches + 0.005<br>- 0.004 | 0.124<br>0.115 |      |                  |
| 8                   | Support     | 2.439inches ± 0.010            | 2.449<br>2.429 |      |                  |
| 9                   | Support     | 1.980inches ± 0.010            | 1.990<br>1.970 |      |                  |
| 10                  | Support     | 0.130inches ± 0.030            | 0.160<br>0.100 |      |                  |
| 11                  | Support     | 0.257inches + 0.005<br>- 0.000 | 0.262<br>0.257 |      |                  |
| 12                  | Support     | 0.375inches ± 0.010            | 0.385<br>0.365 |      |                  |
| 13                  | Support     | 0.875inches ± 0.010            | 0.885<br>0.865 |      |                  |
| 14                  | Support     | 0.500inches ± 0.010            | 0.510<br>0.490 |      |                  |
| 15                  | Support     | 0.400inches ± 0.010            | 0.410<br>0.390 |      |                  |
| 16                  | Support     | 1.000inches ± 0.030            | 1.030<br>0.970 |      |                  |
| 17                  | Support     | 1.720inches ± 0.010            | 1.730<br>1.710 |      |                  |
| 18                  | Support     | 0.125inches ± 0.010            | 0.135<br>0.115 |      |                  |
| 19                  | Support     | 0.125inches ± 0.010            | 0.135<br>0.115 |      |                  |

Plex 2/21/18 3:06 PM dart.lacelle.linda



Container No: S047523



Part: D3278-1

Job No: 172750

Serial No/Batch: S047523

Revision:

Inspector:

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